

Date: Tuesday, 11/11/2008 8:06:53 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 43301		
Estimate Number	: 11139		
P.O. Number	:	Part Number	: D32051
This Issue	: 11/11/2008 S.O. No. :	Drawing Number	: D3205 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 35854	Material	:
Written By	: <i>J.L. 08.10.11</i>	Due Date	: 18/11/2008 Qty: 5 Um: Each
Checked & Approved By	:		
Comment	: Est A 04.06.09 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T73B2500X0325	7075-T73 Bar 2.50 x 3.25
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Comment: Qty.: 0.3828 f(s)/Unit Total : 1.9142 f(s)

7075-T73 Bar 2.5 x 3.25"

Material: 7075-T73 (QQ-A-200/11 or QQ-A-250/12) or 2024-T3 (QQ-A-200/3 or QQ-A-250/4)
(M7075T73B2.500x03.25)

Identify for D3205-1

Batch: *M107955*

J.F 08/11/12 (2) Scrap

J.L 08/11/11 (5)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

J.L 08/11/11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3205-1 as per Folio FA346 and Dwg D3205

Identify as D3205-1

Deburr and Tumble

PTO

J.P 08/11/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.P 08/11/11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

H.A 08/11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3205-1 PAR #: N/A Fault Category: Red. Mach. NCR: Yes No DQA: A Date: 08.11.26
 (D412-704-041) Resolution: Scrap Disposition: Scrap QA: N/C Closed: AJ Date: 08/11/27

NCR: <u>43301</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/11/12</u>	<u>3.0</u>	<u>2 parts are scrap when machining the first operation on Haas #1</u>	<u>[Signature]</u>	<u>Parts are scrap; replaced. Qty 2 M 107955</u> <u>Identify the scrap material for tooling use only.</u>	<u>[Signature]</u> <u>08/11/12</u>	<u>[Signature]</u> <u>08/11/24</u>	<u>[Signature]</u> <u>08/11/24</u>	<u>[Signature]</u> <u>08.11.12</u>
<u>[Arrow]</u>	<u>[Arrow]</u>	<u>R.C. When cutting blank material the saw cut the blank crooked so the part is not square.</u>	<u>[Signature]</u>	<u>Order the appropriate carbide inserts for the Jaespa. to ensure the blanks cut well</u> <u>See P/O # <u>2586</u></u>	<u>[Signature]</u> <u>08/11/24</u>	<u>[Signature]</u> <u>08.11.24</u>	<u>[Signature]</u> <u>08/11/24</u>	<u>[Signature]</u> <u>08.11.12</u>
<u>08-11-12</u>	<u>3.0</u>	<u>Saw miss carbide insert for the Blade.</u> <u>Process TOOLING</u>	<u>[Signature]</u>				<u>[Signature]</u> <u>08/10/12</u>	<u>[Signature]</u> <u>08.11.12</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43301

Part Number: D32051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(5X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-F 08/11/17

7.0

POWDER COATING

POWDER COATING



(5X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the thread hole for D3205-1 before powder coat.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
320°F
2:30

M-F 08/11/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-20 (KS)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(5X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 200

8/11/20

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/24

Job Completion



M-F 08-11-21

DART AEROSPACE LTD		Work Order: 43301
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.108	✓			
0.250	+/-0.010	.250	✓			
R0.37	+/-0.030	.370	✓			
0.125	+/-0.010	.130	✓			
0.250	+/-0.010	.253	✓			
2.380	+/-0.010	2.386	✓			
1.380	+/-0.005	1.380	✓			
0.500	+/-0.005	.496	✓			
0.880	+/-0.010	.881	✓			
Ø0.470 x 100°	+0.005/-0.000	.468 x 100°				
0.440	+/-0.005	.437	✓			
0.600	+/-0.005	.596	✓			
1/4-28UNF-313	N/A	1/4-28	✓			
0.250	+/-0.010	.250	✓			
Ø0.257	+0.005/-0.000	.257	✓			
1.750	+/-0.010	1.752	✓			
0.870	+/-0.005	.870	✓			
0.440	+/-0.005	.436	✓			
R0.25	+/-0.030	.250	✓			

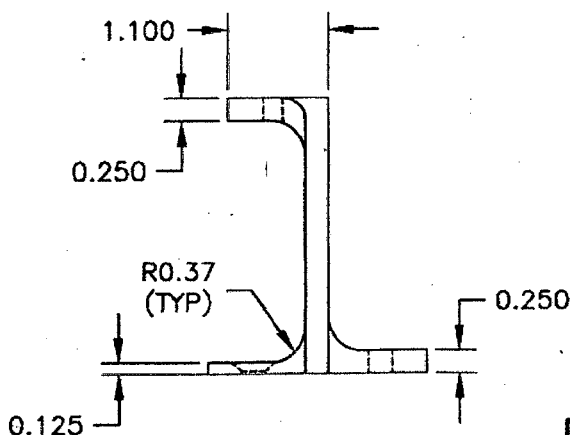
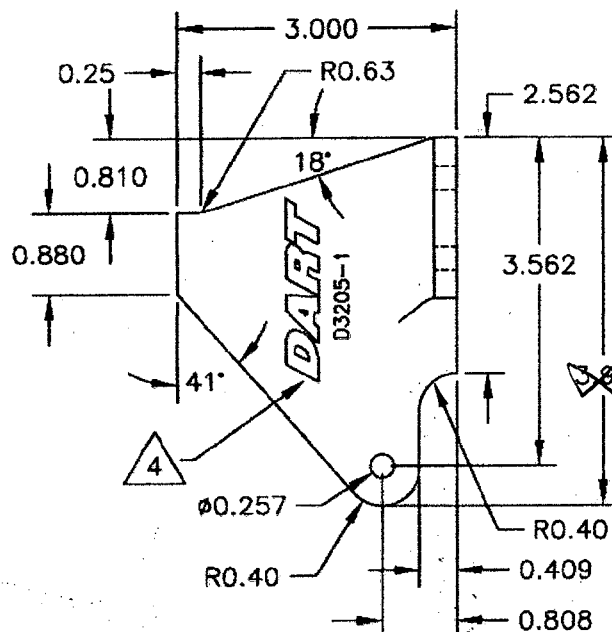
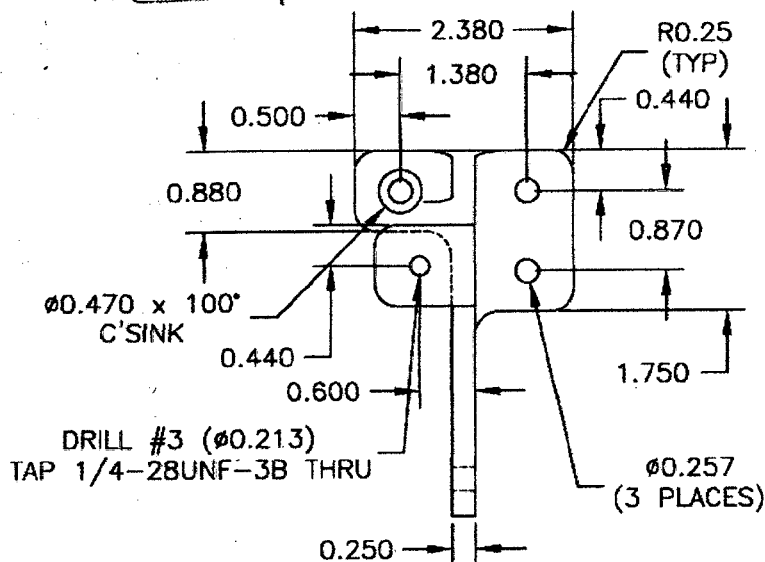
Measured by: SP	Audited by: H.A	Prototype Approval:	N/A
Date: 08/11/11	Date: 08/11/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

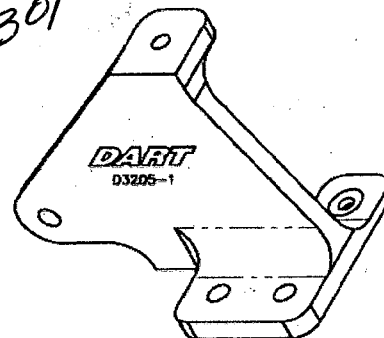


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27	TITLE BRACKET	SCALE 1:2	
A	04.01.27	NEW ISSUE	

RELEASED
010405 #



w/o 4330/



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

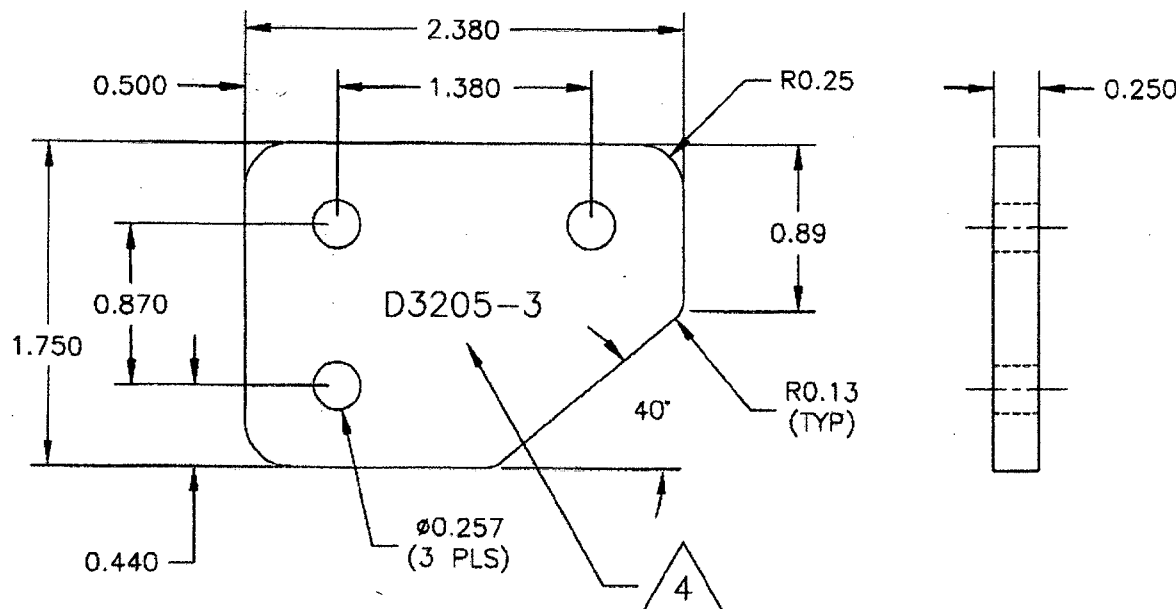
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DESIGN	DRAWN BY	DART AEROSPACE LTD
11	11	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
11	11	D3205
DATE	TITLE	SCALE
04.01.27	BRACKET	1:1
		SHEET 2 OF 2

RELEASED
04.01.27



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

W/O 43301